

Work Order ID 78940

78940

Page 1

January-17-12 1:29:25 PM

Item ID: D3140-05 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door
 Start Date: 17/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3140	Rev F								

100 0.00
100
 Packaging Memo 0.00 1 12/09/21
 Packaging Pick kit to ship to Delastek

110 0.00
110
 QC QC4- 100% Inspect kits for completeness 0.00 CZ 13/10/21
 Quality Control Memo 0.00
 N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120		0.00							
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120

Purchasing

Purchasing

Memo

Issue P/O: 16439
 Purchase Part Number: D3140-05
 Supplier: Delastek
 Ship kit and make as per dwg
 Conformity Certificate and Process sheet required

130	Receive & Inspect for Damage & Mat'l Certs	0.00							
-----	--	------	--	--	--	--	--	--	--

130

Packaging

Packaging

Memo

0.00

140	QC6- Inspect dimensions to drawing	0.00							
-----	------------------------------------	------	--	--	--	--	--	--	--

140

QC

Quality Control

Memo

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

Material certs Attach. to

w/ 78942

CL 12/02/17 1

163/3/13 ①

DAS
16
13/05/02

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Required Date: 31/01/2012 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00				<u>0</u>	<u>8</u>	<u>13-10-14</u>	
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

Handwritten: 13-10-14

Handwritten: 13-10-18

Handwritten: 13-10-10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

January-17-12 1:29:28 PM

78940

D3140-05


Required Date: 31/01/2012

Required Qty: 1.00

Comments: IPP REV:A 12.01.17 NEW ISSUE DD VERF:JLM

[illegible]

D 3140-05 P

13/3/13  78940

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED #	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

RELEASED

06.11.13 #

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO COMPANY POLICY

WITH THE NOTICE

WORKING COPY

NO. 78940-HL-5
12/01/17

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED Jh	APPROVED #	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED

06.11.13

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

14

PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
ALODINE PER DART QSI 005 4.1



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018940

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[illegible]

RELEASED

06.11.13

TAPER A/R AS SHOWN
PER TOOL # B30-23000-57T
(2 PLACES)

1.00 REF

1.00 REF

D3140-63 (REF)

D3140-61 (REF)

D3140-63 (REF)

E761/7781
3 PLY
THRU OUT INNER SHELL

R0.50

D3140-59 (REF)

D3140-57
(3 PLACES)

FILL IN GAPS
& BOND PADS
MA560 FOAM
(A/R)

SECTION B-B

E761/7781
3 PLY
THRU OUT SHELL

ALL OUTER RADII
PER TOOL # B30-23000-01T/-02T

D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
 (WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

Three triangles are shown, labeled 1, 2, and 3 from left to right. Each triangle is an isosceles triangle with its base at the bottom. The numbers 1, 2, and 3 are centered inside each triangle respectively.

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN

10

DATE	11/11/2011
DRAWN BY	11/11/2011

	D
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PART

DART AEROSPACE LTD.

DAIIC AEROSPACE LTD.
HAMPSHIRE, ONTARIO, CANADA

CHECKED	DATE
---------	------

APPROVED

DRAWING NO.

REV. F

DATE _____

TITLE

SCALE

06.10.06

DOOR

NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

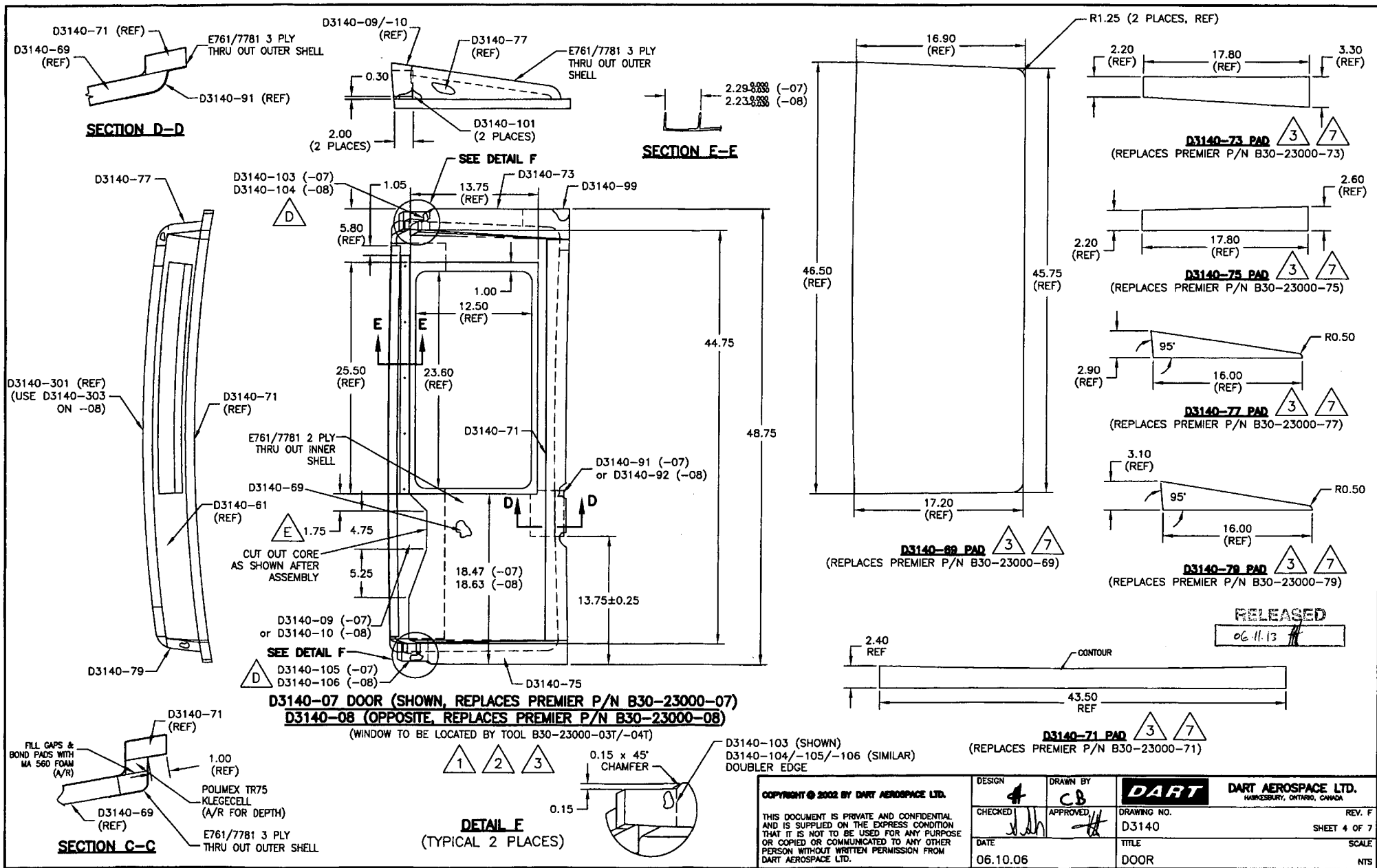
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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78946



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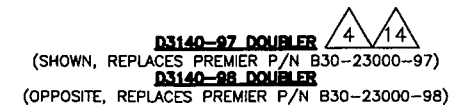
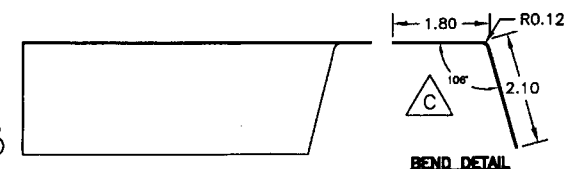
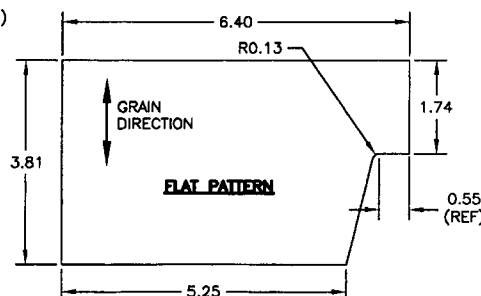
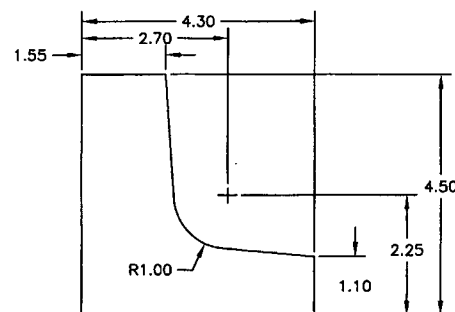
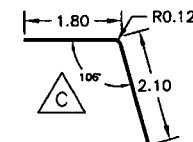
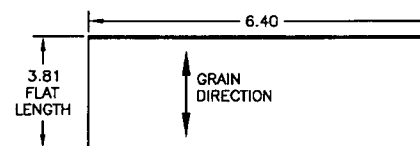
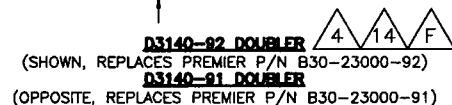
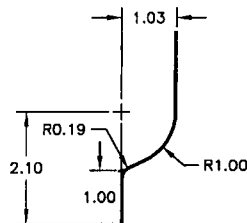
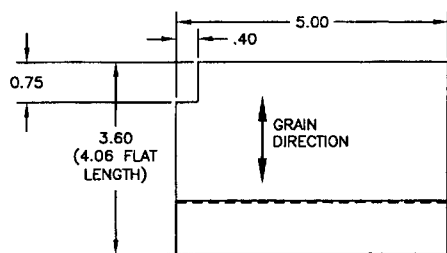
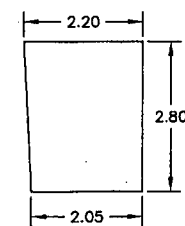
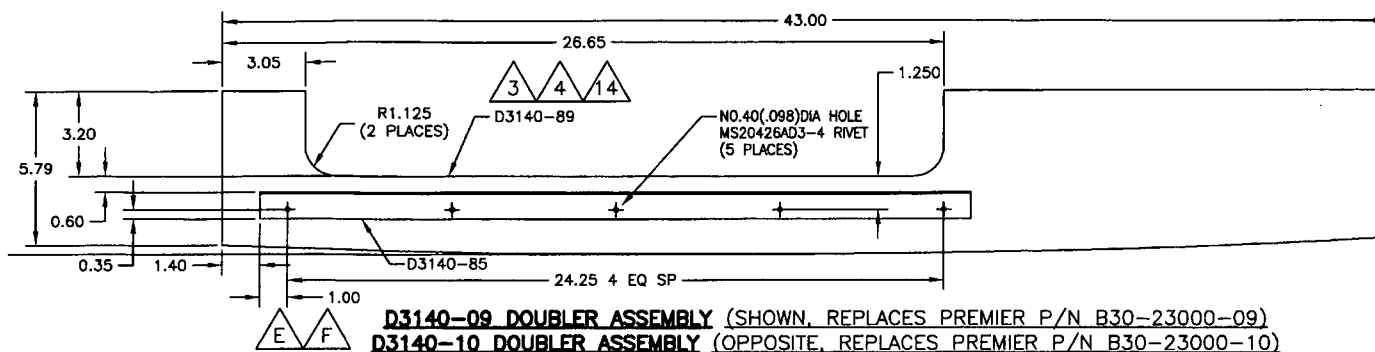
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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RELEASED

06-11-13

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DESIGN	4	DRAWN BY	CB	DART	DART AEROSPACE LTD. WILKESBURY, ONTARIO, CANADA
CHECKED	dh	APPROVED	dh	DRAWING NO.	REV. F
DATE	06.10.06	TITLE	DOOR	D3140	SHEET 5 OF 7
					SCALE
					NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

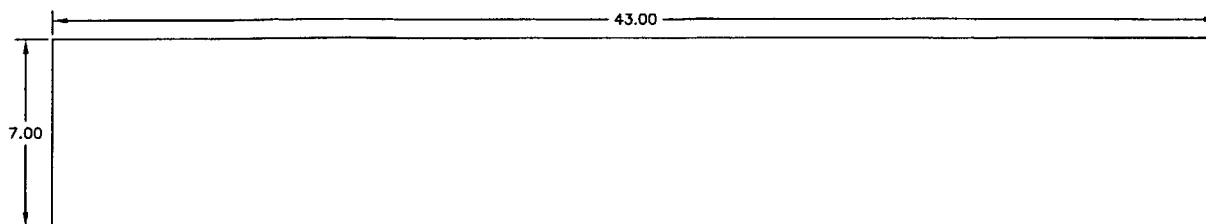
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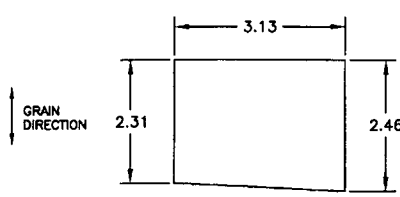
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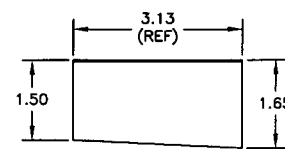
78940



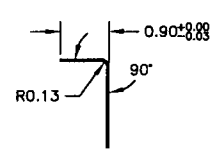
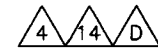
D3140-87 DOUBLER
(REPLACES PREMIER P/N B30-23000-87)



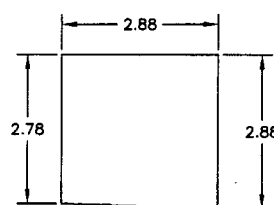
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)



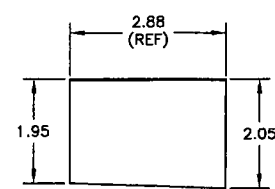
D3140-105 DOUBLER
D3140-106 OPPOSITE



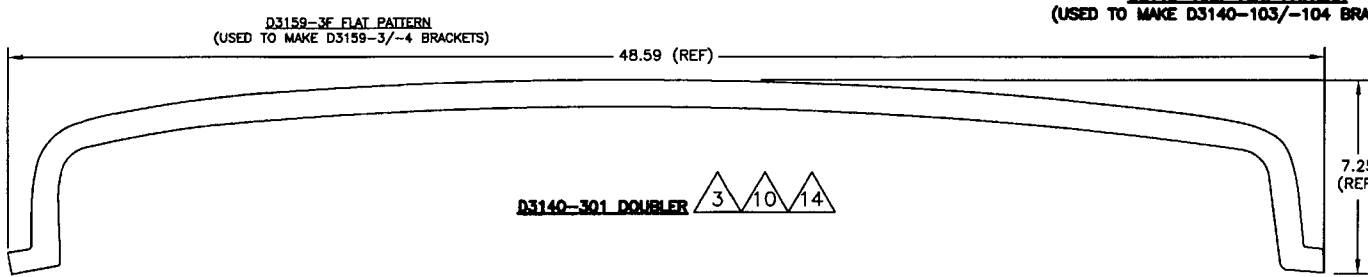
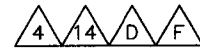
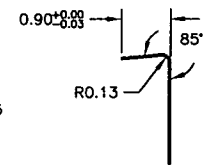
GRAIN DIRECTION



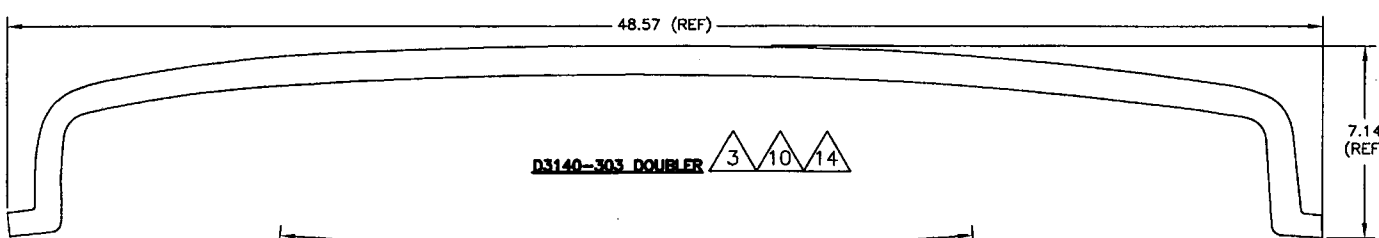
D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



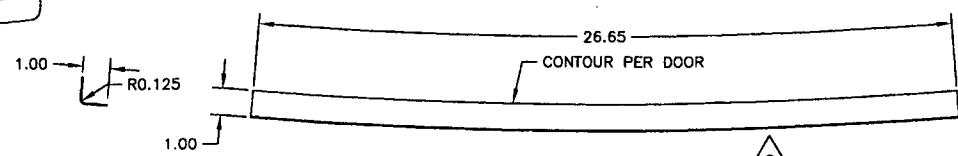
D3140-104 DOUBLER
D3140-103 OPPOSITE



D3140-301 DOUBLER



D3140-303 DOUBLER



D3140-85 ANGLE
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

RELEASED
2011-13

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DATE 06.10.06		TITLE DOOR		SHEET 6 OF 7 SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

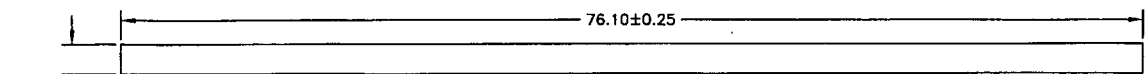
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

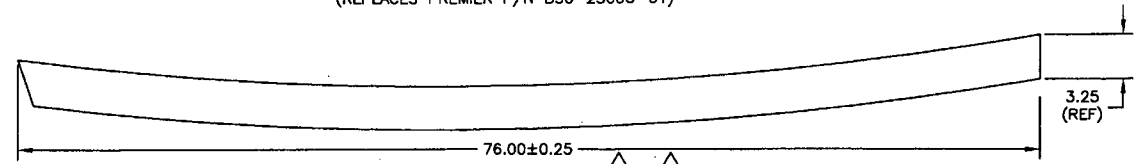
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

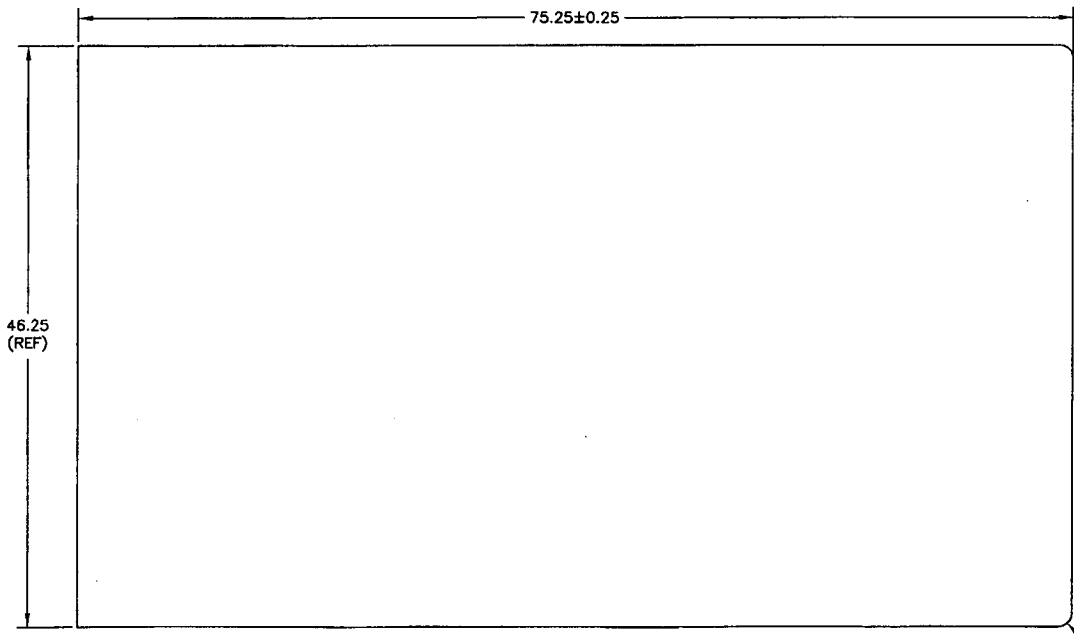
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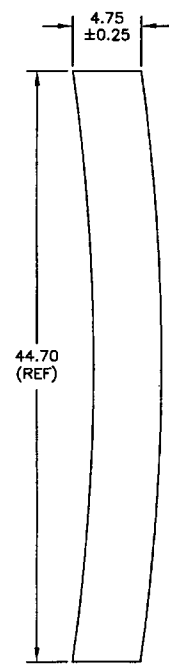
D3140-61 PAD 3 7
(REPLACES PREMIER P/N B30-23000-61)



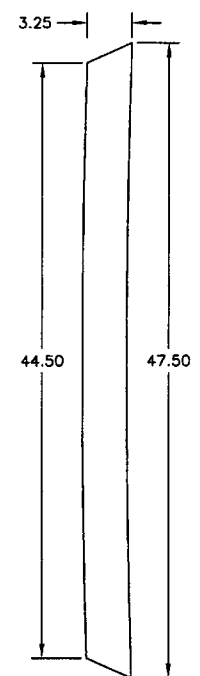
D3140-63 PAD 3 7
(REPLACES PREMIER P/N B30-23000-63)



D3140-59 PAD 7
(REPLACES PREMIER P/N B30-23000-59)



D3140-57 PAD
(REPLACES PREMIER P/N B30-23000-57)
3 7



D3140-241 DOUBLER 5 14
(REPLACES PREMIER P/N B30-23000-241)

RELEASED
06.11.13

R1.00
(2 PLACES, REF)

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DESIGN 4	DRAWN BY CB	DART	DART AEROSPACE LTD. WILKESBORO, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	REV. F SHEET 7 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16439

Purchase Order Date 3/14/12

PO Print Date 4/23/12

Page Number 1 of 2

Order From :

VU-DEL003

DELASTEK INC

2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7

CA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

819 533 5788

819 533 3494

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

USD

Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3140-05P	DOOR	7/06/12 Yes	1.00 Each		\$8,062.5000	\$8,062.50
		Special Inst:	AS PER DWG D3140 REV. F B78940				
2	D3140-06P	DOOR	7/06/12 Yes	1.00 Each		\$8,062.5000	\$8,062.50
		Special Inst:	AS PER DWG D3140 REV. F B78941				
3	D3140-07P	DOOR	7/06/12 Yes	1.00 Each		\$8,062.5000	\$8,062.50
		Special Inst:	AS PER DWG D3140 REV. F B78942				
4	D3140-08P	DOOR	7/06/12 Yes	1.00 Each		\$8,062.5000	\$8,062.50

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr:

3

Change Date: 4/23/12